

5/46

DART AEROSPACE LTD	Work Order:	24682
Description: Rod	Part Number:	D3134-3
04.11.29 25.12.05		(p B30-23000-139)
Dwg: D3134 Rev. B/C D	Qty:	4
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	RF	05.10.26	4
2	GA	Cut material to length as per template D3134-3/-4T1 Material: AISI 304/316 Annealed SS tubing 0.250OD x 0.049 wall (M304TR0.250W.049) Batch: (M18960)	ml	05/11/28	4
3	GA	Open both ends with Ø0.161 (#20) drill and thread both ends as per Dwg D3134	ml	05/11/28	4
4	GA	Deburr rod, no sharp edges.	ml	05/12/05	4
5	GA	Bend as per Dwg D3134 using template D3134-3T3	ml	05/12/05	4
6	QC5	Inspect work for Completeness on the W/O	RF	05-12-19	4
7	ST	Identify and Stock with P/N & B/W using fine point permanent ink marker	ml	05/12/19	4
8	AC	Cost / part	Sus	05-12-21	4
9	DC	Close W/O Inspect Level 21	RF	05/12/21	4

PTO

Rev	Date	Change	Revised By	Approved
A	02.05.27	New issue	NG	
B	02.11.12	Re-format; Add thread	KJ RF	

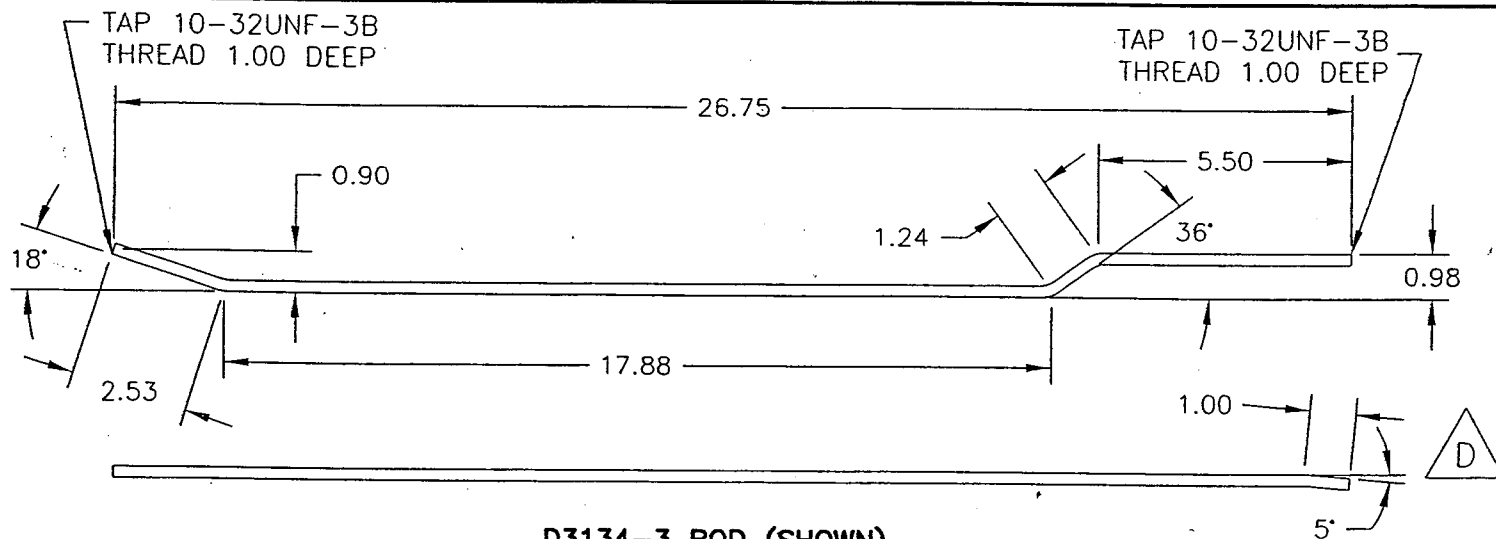
RELEASED
02.11.18 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3134-3 PAR #: _____ Fault Category: Prod/Fab. PSS ^{med-small} NCR: (Yes) No DQA: (D) Date: 05/12/21
 QA: N/C Closed: (D) Date: 05/12/21

NCR: <u>24682</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>ml</u> <u>05/12/05</u>	<u>5</u>	<u>Scrap 26 " of tubing</u> <u>M304 TRO. 2D W. 049</u> <u>to find the good dimension</u> <u>for bending. They were not</u> <u>on the template.</u>	<u>(Signature)</u> <u>05/12/05</u>	<u>Take out</u> <u>the inventory</u>	<u>ml</u> <u>05/12/05</u>	<u>2</u> <u>05.12.21</u>	<u>(Signature)</u> <u>05.12.21</u>	<u>2</u> <u>05.12.21</u>

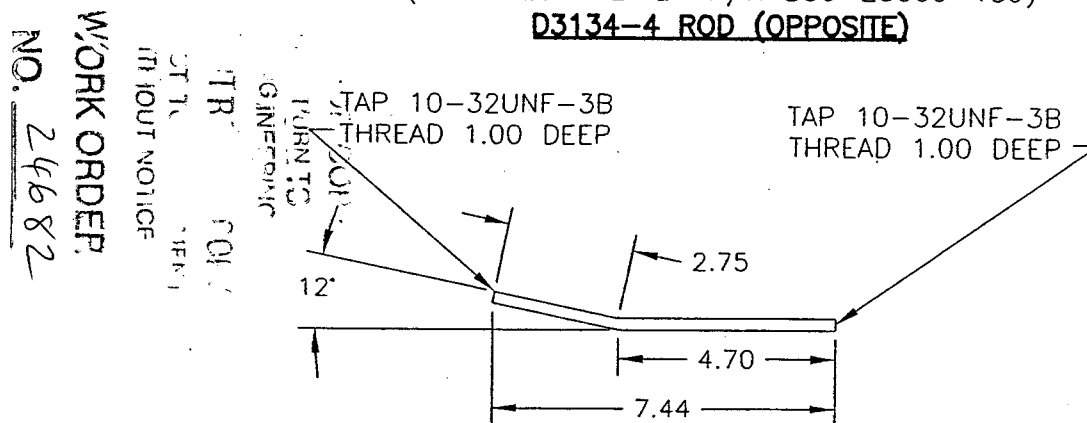
NOTE: Date & initial all entries



D3134-3 ROD (SHOWN)

(REPLACES PREMIER P/N B30-23000-139)

D3134-4 ROD (OPPOSITE)



D3134-1 ROD

(REPLACES PREMIER P/N B30-23000-137)

NOTES

- 1) MATERIAL: AISI 304/316 ANNEALED SS TUBING 0.250 OD x 0.049 WALL
(REF DART SPEC. M304TR0.250W.049)
- 2) TOOLING: MAKE D3134-1 PER TOOL DT8656
MAKE D3134-3 PER TOOL DT8657
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DESIGN	DS	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.12.05	TITLE	D3134	REV. D
		ROD		SHEET 1 OF 1
				SCALE
				NTS
A	02.04.17	NEW ISSUE		
B	02.09.26	ADD "ANNEALED" SPEC; REDESIGNED D3134-1		
C	04.10.18	ADD PART MARKING		
D	05.12.05	CORRECT VIEW		

RELEASED
05.12.05

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 25, 2005
04:04 pm

Work Order No : 0024682
Project Name : D3134-3
Project For : WK546
Work Order Type : Main
Main WO Number :
House Part Number : D3134-3
Description : Rod
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 10-25-05
Est Finish Date : 11-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00